

Work Order ID 86244

86244

Page 1

Item ID: D4095-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 25/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-5)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304.063

10 0 Jm 12-7-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-7-3

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/2/2013

(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86244

86244

Page 2

June-25-12 10:34:15 AM

Item ID: D4095-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Assembly

Stop

NS2

Start Date: 25/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | NC BRAKE | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | 10 | | | 25/07/12 |
| Brake NC | Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Joggle as per Dwg D3564 on brake using Jig DT8157 | | | | | 10x | | | 25/07/12 |
| 140 | | 0.00 | | | | | | | |
| *140* | QC5- Inspect part completeness to step on W/O | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | 16 25/07/12 |
| Quality Control | | | | | | | | | 16 |
| 150 | | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | 12-7-24 |
| Hand Finishing | COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 122237 | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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86244

Page 3

June-25-12 10:34:15 AM

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 25/06/2012 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|---------------------------------|----------------|
| 160 *160* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 10 | 0 | 12-7-25 | |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: <u>FR-1</u> Memo | 0.00 0.00 | | | | 10 | 0 | 12-7-25 | |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | MLT 12/07/25 MME 12-07-25 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|--|---|
| A | 11.11.08 | New Issue P/O D4095-045 | KJ  |  |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

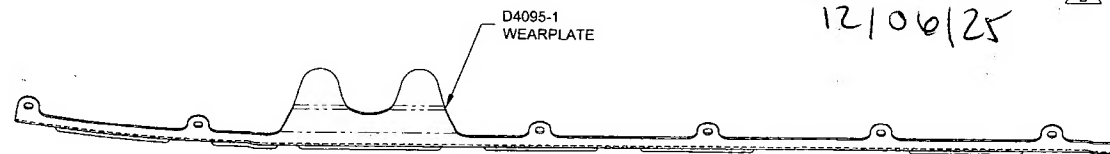
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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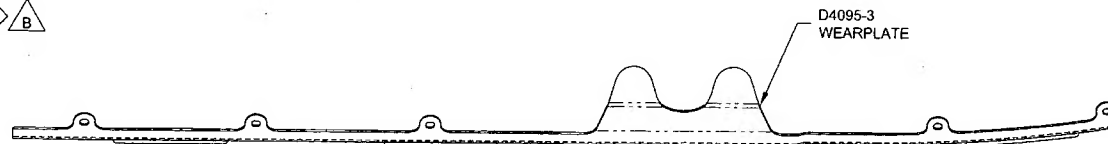
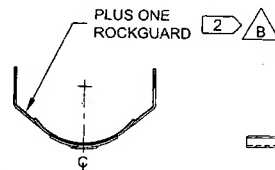
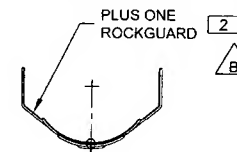
NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06244 MLC
12/06/25

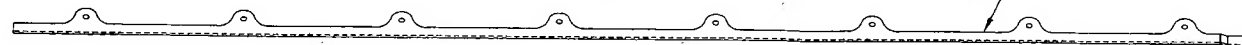
| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | PART NUMBER | DESCRIPTION |
|------|----------|----------|----------|----------|----------|----------|-------------|--------------------------------|
| 1 | X | | | | | | D4095-041 | WEARPLATE ASSEMBLY |
| 2 | | X | | | | | D4095-043 | WEARPLATE ASSEMBLY |
| 3 | | | X | | | | D4095-045 | WEARPLATE ASSEMBLY |
| 4 | | | | X | | | D4095-047 | WEARPAD ASSEMBLY |
| 5 | | | | | X | | D4095-049 | WEARPAD ASSEMBLY |
| 6 | | | | | | X | D4095-051 | WEARPAD ASSEMBLY |
| 7 | 1 | | | | | | D4095-1 | WEARPLATE |
| 8 | | 1 | | | | | D4095-3 | WEARPLATE |
| 9 | | | 1 | | | | D4095-5 | WEARPLATE |
| 10 | | | | 1 | | | D4095-7 | WEARPAD |
| 11 | | | | | 1 | | D4095-9 | WEARPAD |
| 12 | | | | | | 1 | D4095-11 | WEARPAD |
| 13 | A/R | A/R | A/R | A/R | A/R | A/R | 4715 (4714) | PLUS ONE ROCKGUARD BLACK (TAN) |



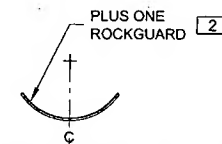
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

| | | | |
|------------|---|-----|----------|
| B | REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2 | XDF | 11.10.18 |
| A | NEW ISSUE | MB | 10.04.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | XDF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.10.18 | | |

DART AEROSPACE USA, INC
KENT, WA
DRAWING NO. D4095
TITLE WEARPLATE
REV. B
SHEET 1 OF 8
SCALE NTS
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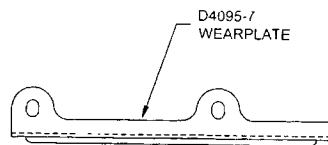
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

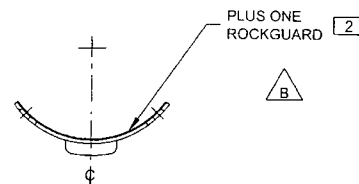
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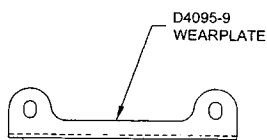
NOTE: Date & initial all entries



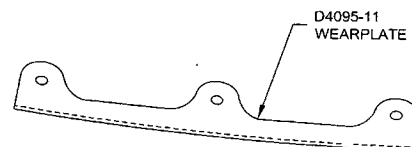
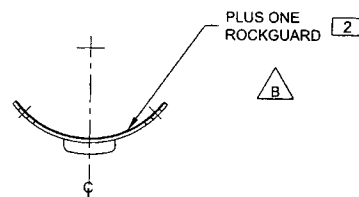
D4095-047 WEAR PAD ASSEMBLY



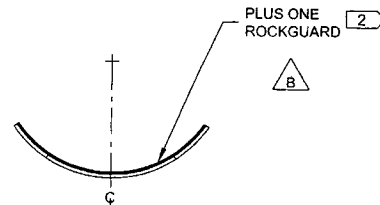
86244



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-3

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| DRAWN | XDF | KENT, WA | |
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| MFG. APPR. | 10 | D4095 | SHEET 2 OF 8 |
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Dart Aerospace Ltd

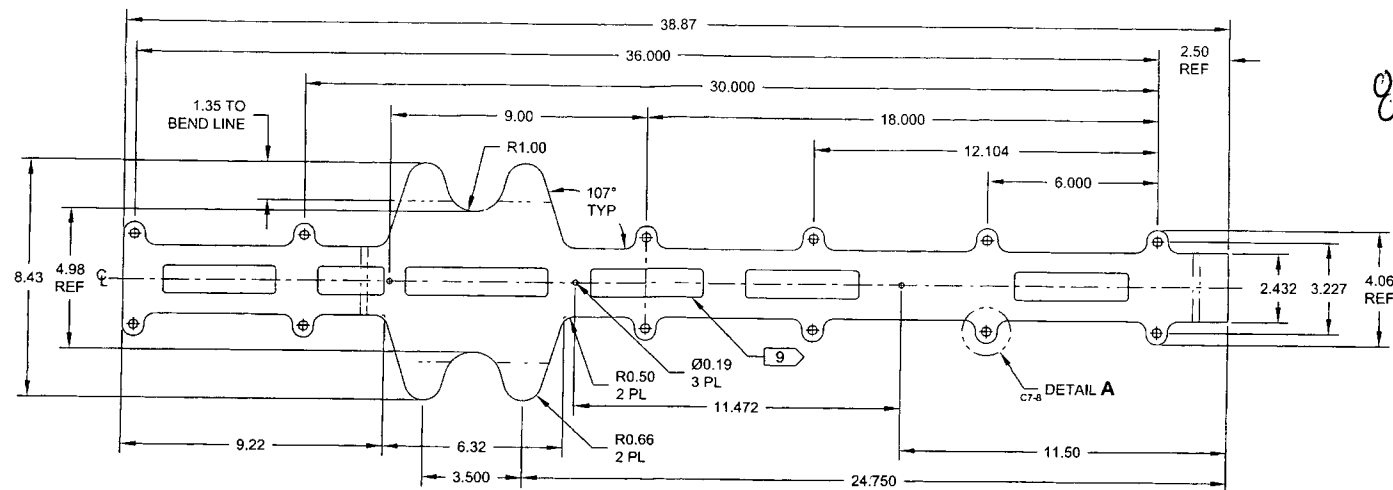
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

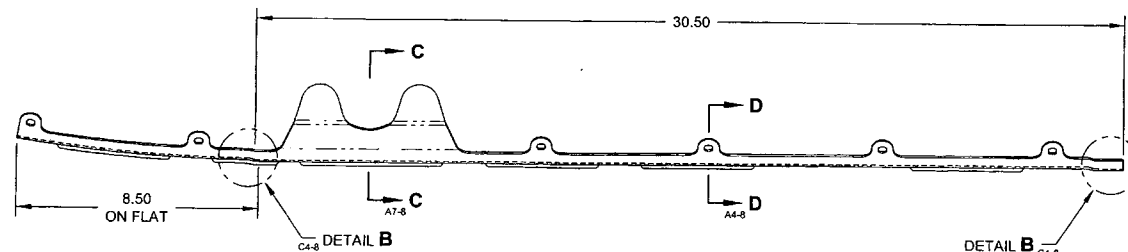
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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|---|----------|---|--------------|
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| DRAWN | XDF | KENT, WA | |
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| MFG. APPR. | 10 | D4095 | SHEET 3 OF 8 |
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2011-10-31
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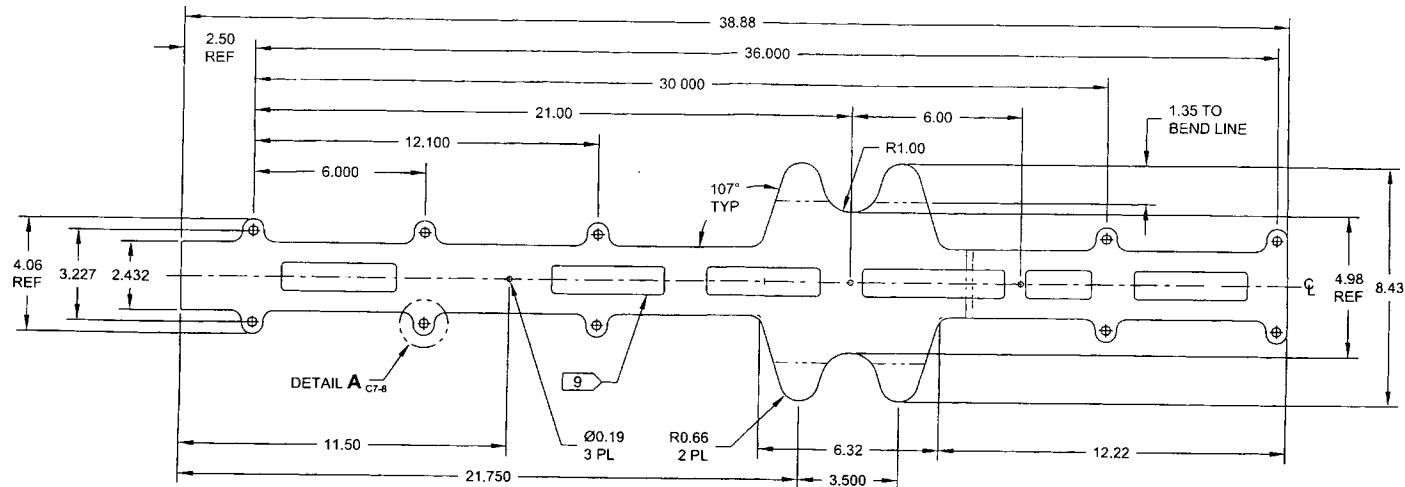
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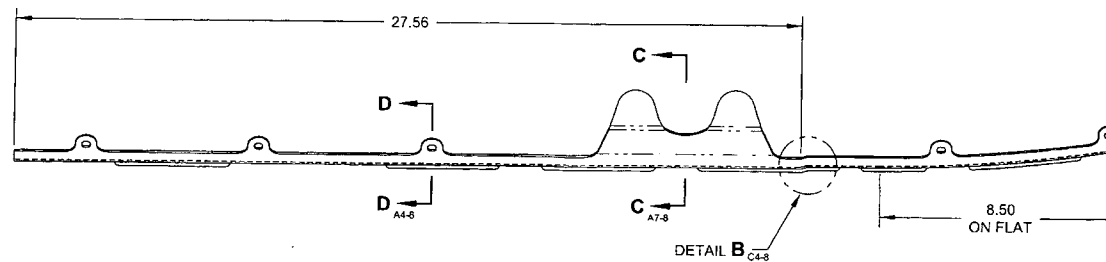
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NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

RELEASE
2011-10-31

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| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
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| MFG. APPR. | <i>[Signature]</i> | D4095 | SHEET 4 OF 8 |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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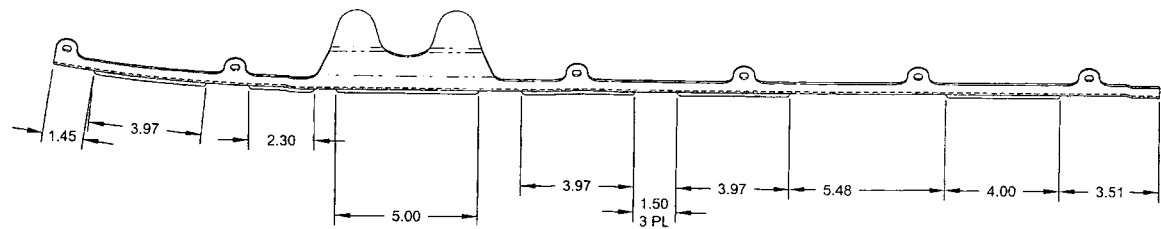
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

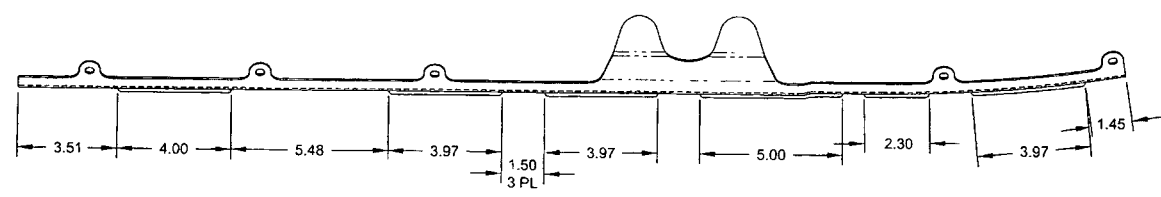
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NOTE: Date & initial all entries

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





D4095-1 WELDING DETAIL 



D4095-3 WELDING DETAIL 

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2011-10-31
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| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
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| MFG. APPR. |  | D4095 | SHEET 5 OF 8 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | WEARPLATE | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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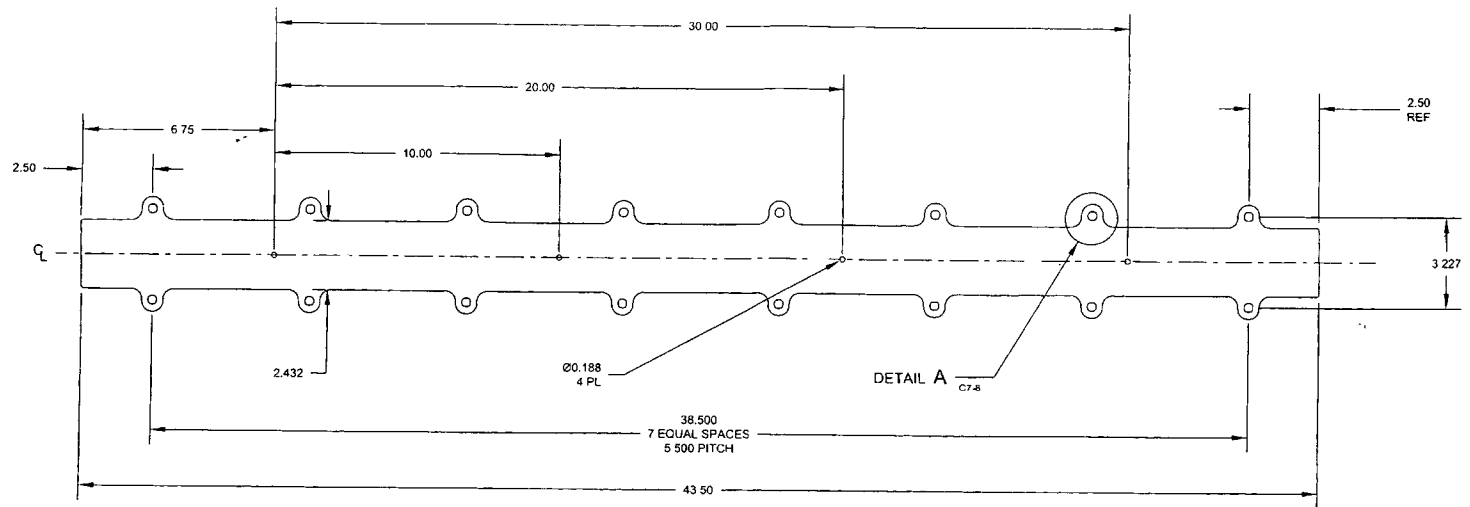
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

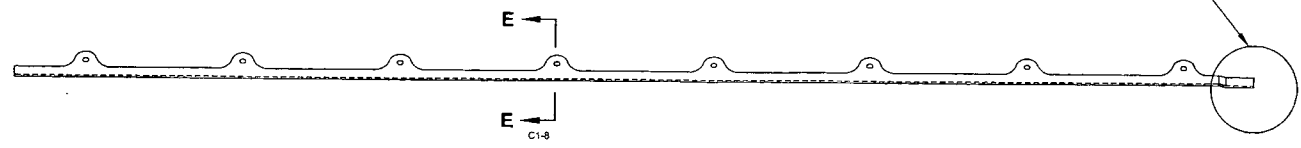
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

86244



D4095-5F FLAT PATTERN 1



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RECEIVED
2011-10-31
NMP

| | | | |
|------------|----------|---|--------------|
| DESIGN | XDF | DART AEROSPACE USA, INC | |
| DRAWN | | KENT, WA | |
| CHECKED | 10 | DRAWING NO. | REV. B |
| MFG. APPR. | 10 | D4095 | SHEET 6 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | WEARPLATE | NTS |
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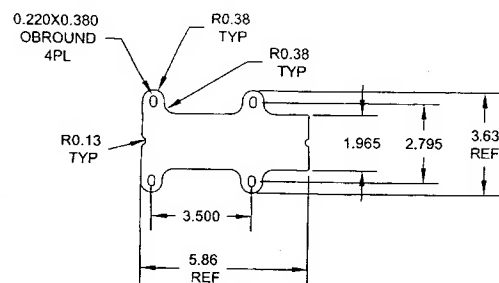
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

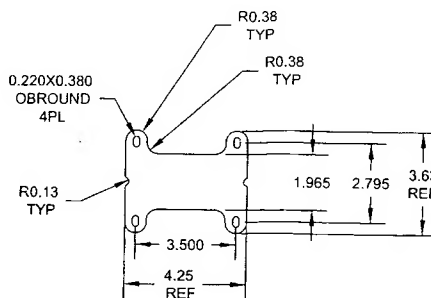
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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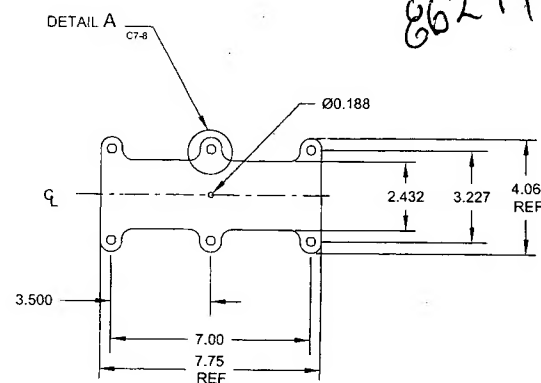
NOTE: Date & initial all entries



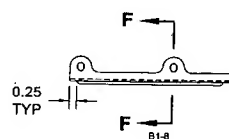
D4095-7F FLAT PATTERN 1



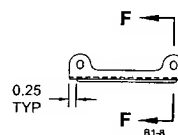
D4095-9F FLAT PATTERN 1



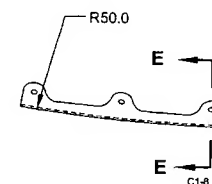
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

| | | | |
|--|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | 10 | DRAWING NO. | REV. B |
| MFG. APPR. | 10 | D4095 | SHEET 7 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | WEARPLATE | NTS |
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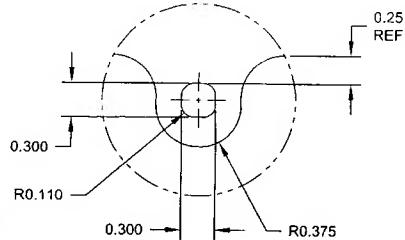
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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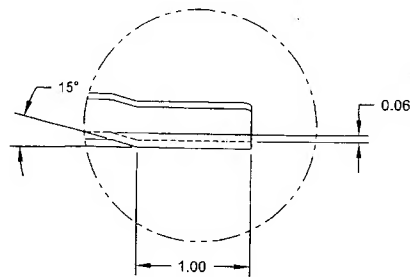
NOTE: Date & initial all entries



DETAIL A: TAB DETAIL

SCALE 4X

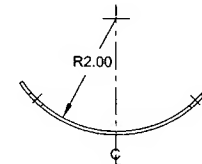
C3-3
C9-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

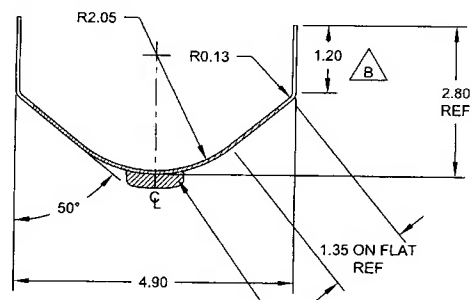
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

RELEASED
2011-10-31
NPD

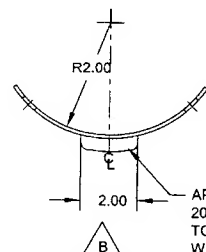


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

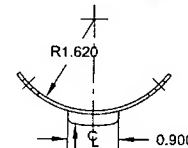


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

| | | |
|------------|----------|--------------------------------|
| DESIGN | | DART AEROSPACE USA, INC |
| DRAWN | XDF | KENT, WA |
| CHECKED | | REV. B |
| MFG. APPR. | | D4095 SHEET 8 OF 8 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | WEARPLATE NTS |
| DATE | 11.10.18 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries